










Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ACCESS PANEL ASSEMBLY
Job Number	: 46973		
Estimate Number	: 12948		
P.O. Number	:	Part Number	: D3259041
This Issue	: 07/04/2009 S.O. No. :	Drawing Number	: <u>D3249 REV A1</u>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 44235	Material	:
Written By	: _____	Due Date	: 30/04/2009 Qty: 6 Um: Each
Checked & Approved By	: <u>JLM 09 04 07</u>		
Comment	: Est Rev:A New Issue 07-07-19 JLM Verified By:EC		

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
 		
Comment: PACKAGING RESOURCE #1 Pick Assembly Kit		
2.0	D32591	Panel
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) ✗ panel Batch: <u>B47188</u> <u>Pg 5/5</u>		
3.0	D32593	Doubler
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) ✗ Doubler Batch: <u>B44302 x5</u> <u>9/5/6</u> <u>B47189</u> <u>①</u> <u>50</u>		
4.0	D32595	Spacer
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Spacer Batch: <u>B43774</u> <u>8809/04/15</u> <u>①</u>		
5.0	D32597	Door
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Door Batch: <u>44304 x3</u> <u>Pg 5/6</u> <u>B47182</u> <u>2x</u> <u>8809/04/15</u> <u>①</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/03/07							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:20:16 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 46973

Part Number: D3259041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D31615	Hinge 9.9"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Hinge 9.9"

Batch: ~~113760~~ M11027 (20) M101334 (40) 88 09/04/15 (x6) P10

7.0	D32601	Spring
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Spring

Batch: B44305 x4 B47193 8p 88 09/04/15 (x6)

8.0	127H5	HALF GROMMET
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

HALF GROMMET

Batch: M11401 88 09/04/15

9.0	250018C3Y	RIGHT RECEPTACLE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

RIGHT RECEPTACLE

Batch: ~~M100341 x2~~ M105932 x6 88 09/04/15 (x6)

10.0	2501W20020C3Y	STUD
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

STUD

Batch: M11018 88 09/04/15 (x6)

11.0	MS20426AD44	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Rivet

Batch: M15541 88 09/04/15 (x6)

12.0	MS20470AD34	Rivet, Universal Head
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Comment: Qty.: 36.0000 Each(s)/Unit Total : 216.0000 Each(s)

Rivet, Universal Head

Batch: M15541 88 09/04/15 (x6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
29/05/07	6	Change D 3161-5 for MS2057-3-7200 Batch M101334 cut Ringe at 9.9" M111027 Permanent chg Dave EC 09.05.07	CP 29/05/07	09/05/07	6	EC 09.05.07	15/05/07

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:20:16 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 46973

Part Number: D3259041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS20470AD35

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 60.0000 Each(s)

Rivet

Batch:

M 9682

28 09/04/15 (6)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3259-041 as per Dwg D3259 .

Note:Keep .040" Gap all around door.

09/05/08 (6)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/11 (6)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST 184

09-05-11 (6) 28

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/11 (6)

Job Completion



mf
09-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

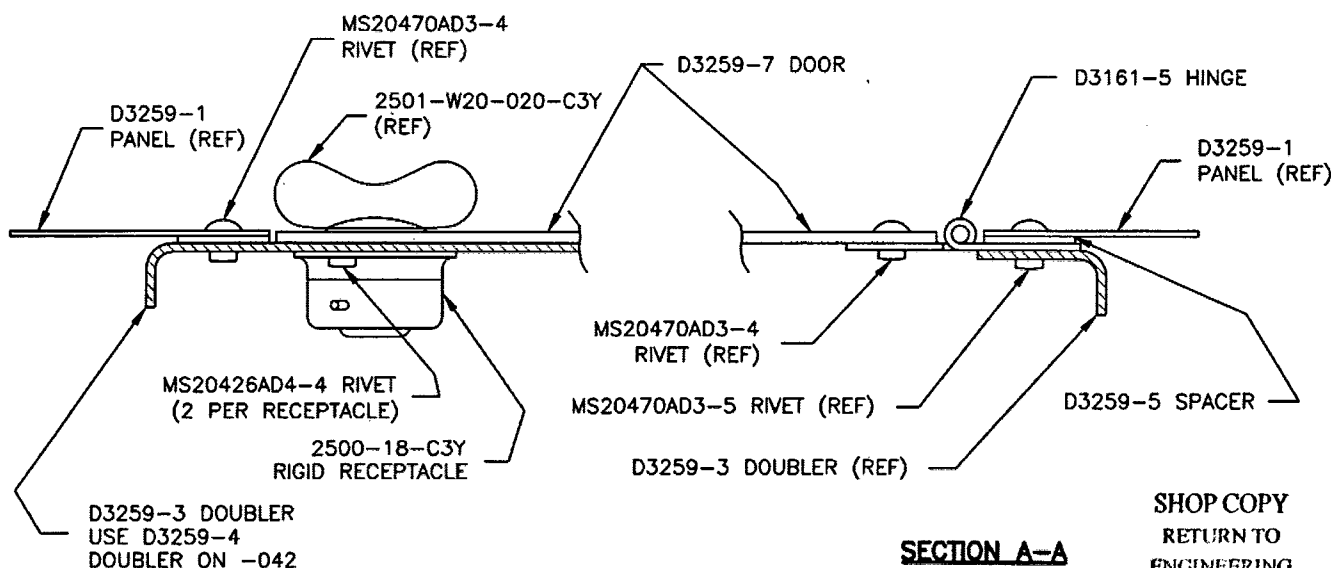
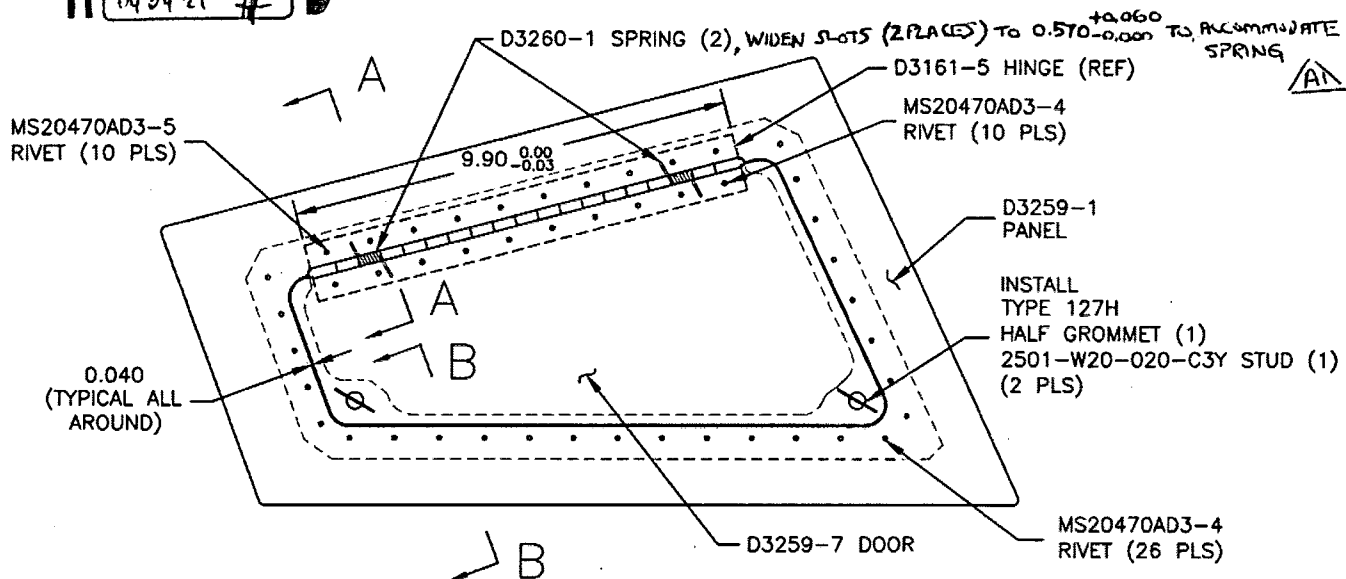
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3259
				REV. A SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE 1:4
A	04.02.25	NEW ISSUE		
AI	CP <i>[Signature]</i> 04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING		

RELEASED
040421 *[Signature]*



SECTION B-B
VIEW ROTATED

SECTION A-A
VIEW ROTATED

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WORK ORDER
NO. 46973

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

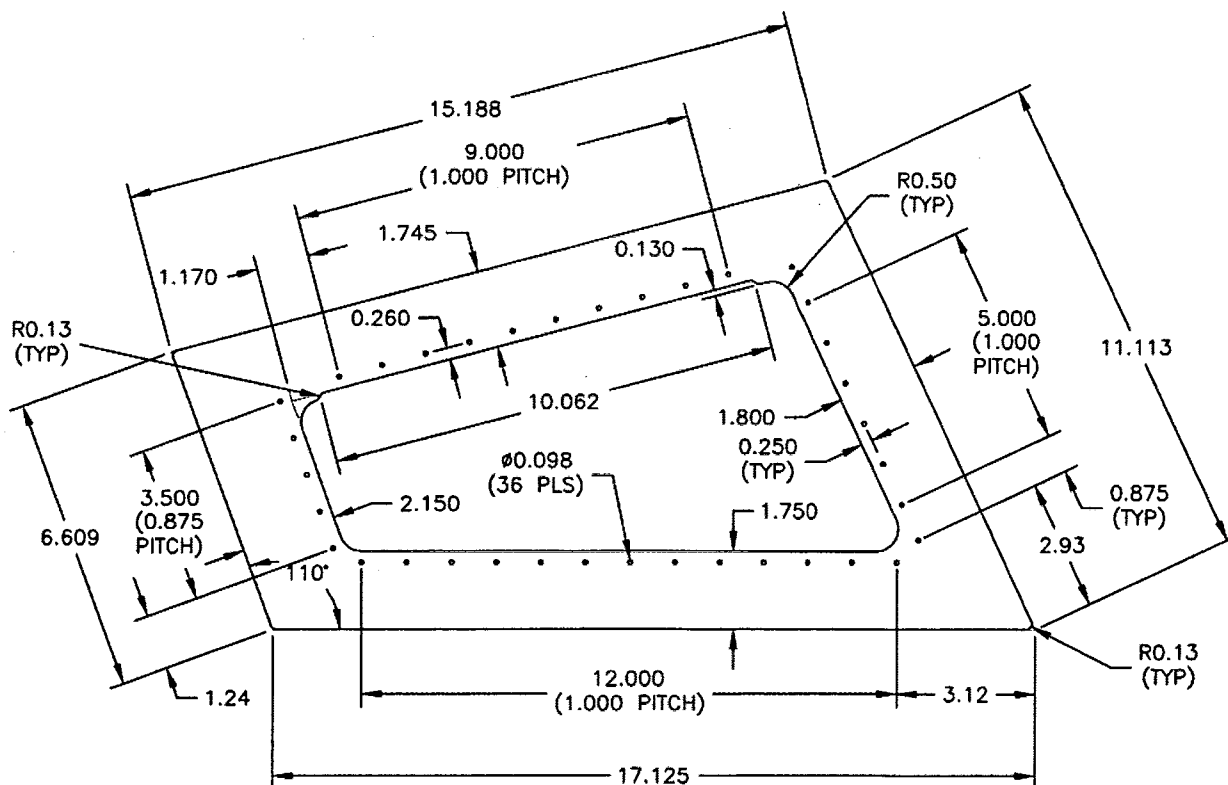
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04 04 05



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

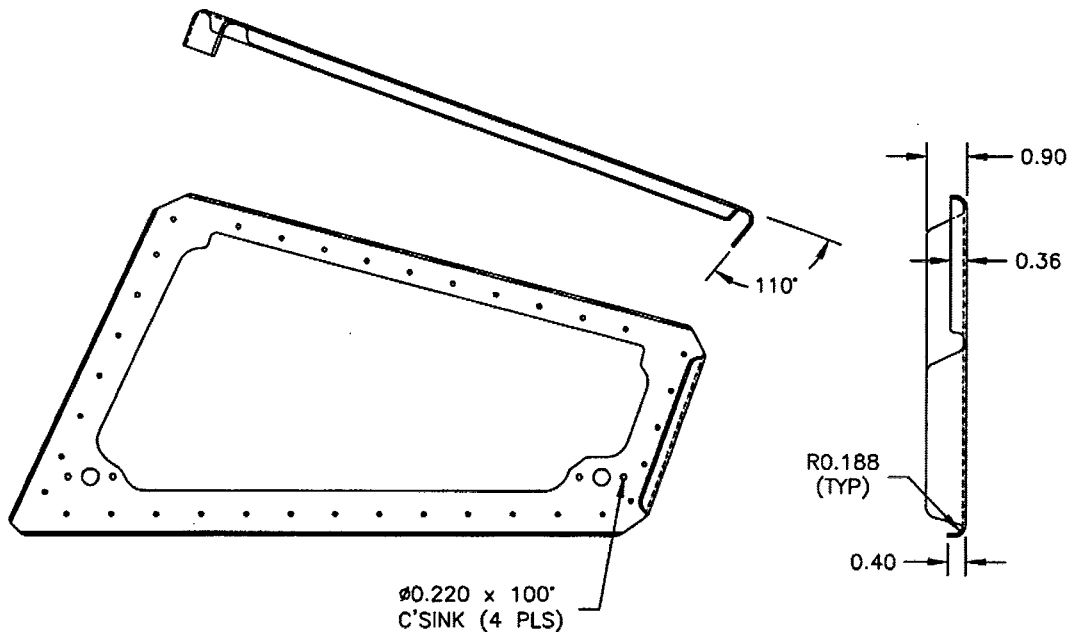
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14 [Signature]**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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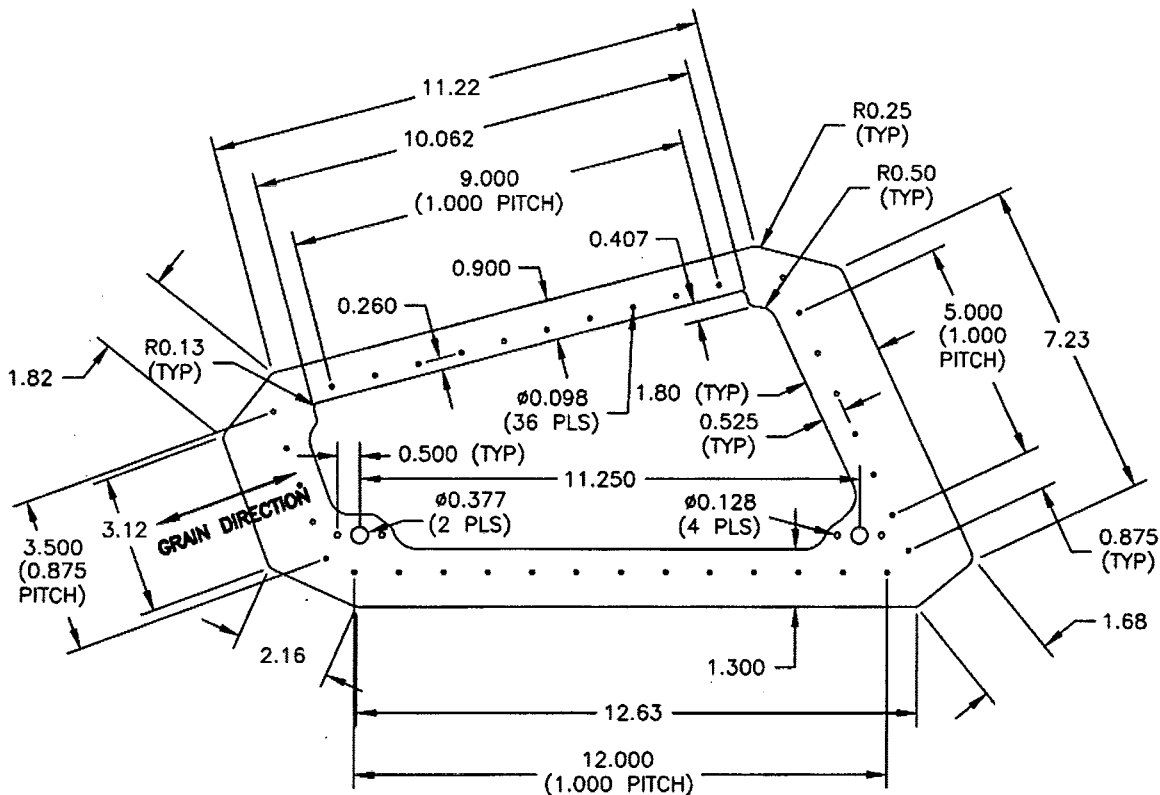
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

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04 04 14



D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

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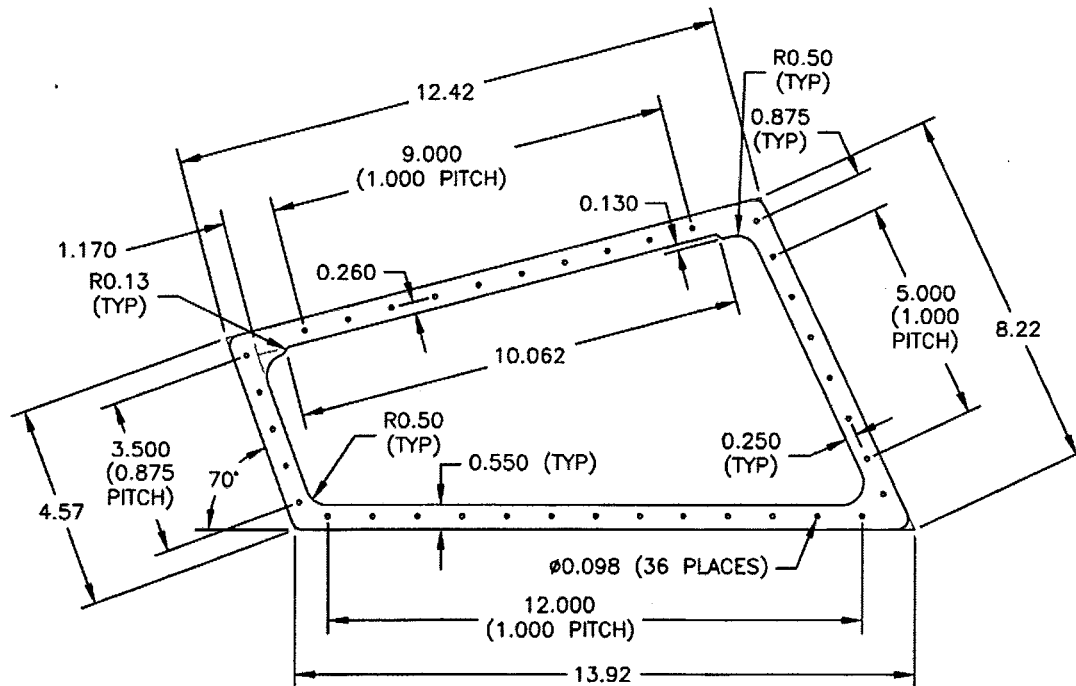
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RELEASED
04-04-05



D3259-5 SPACER

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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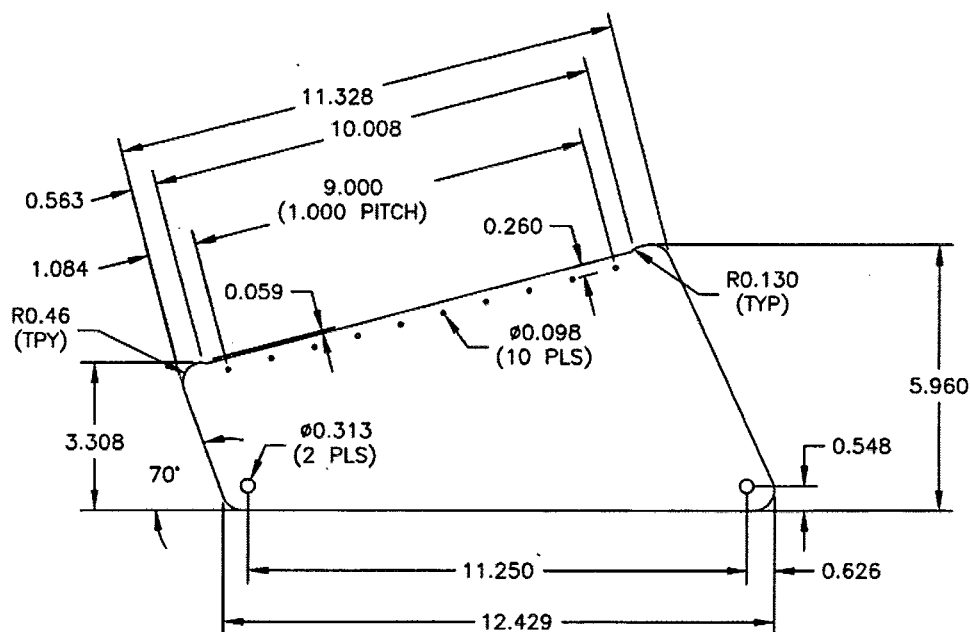
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04 04.14**D3259-7 DOOR****NOTES:**

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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